Work Order ID 62554

Monday, October 04, 2010 10:58:17 AM

Item ID: D350-588-011 **Accept** **Setup** **Start** **Stop**

Revision ID:

Item Name: Aft Door Fwd Hinge Modification

Start Date: 10/4/2010 **Start Qty:** 2.00 **Cust Item ID:**

Required Date: 10/20/2010 **Req'd Qty:** 2.00 **Customer:**

Reference:

Approvals: **Process Plan:** ______ **Date:** 10-10-04 **Tooling:** ______ **Date:** ______ **Run** **Start** **Stop**

QC: ______ **Date:** ______ **SPC (Y/N):** ______ **Date:** ______

Sequence ID/ Work Center ID	Operation Description		Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	**Revision Nbr**									
N/A	Rev N/A									
100 DC Document Control	DOCUMENT CONTROL		0.00							
		Memo Photocopy bluefile and create labels per PPP D350-588-011 CHG002	0.00	8/06/08					BG	10-10-22
110 Packaging Packaging	Pick Kit		0.00							
		Memo	0.00							
120 QC Quality Control	QC4- 100% Inspect kits for completeness		0.00							
		Memo	0.00	8/06/08						

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: ____________________ PAR #: _______ Fault Category: __________________ NCR: Yes No DQA: _____ Date: _________

Resolution: ____________________ Disposition: ____________________ QA: N/C Closed: __________ Date: _________

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
			Corrective Action Section B					
DATE	STEP	Description of NC Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Verification Section C	Approval Chief Eng	Approval QC Inspector

NOTE: Date & initial all entries

Work Order ID 62554

Monday, October 04, 2010 10:58:17 AM

Item ID: D350-588-011 **Accept** **Setup Start** **Stop**

Revision ID:

Item Name: Aft Door Fwd Hinge Modification

Start Date: 10/4/2010 **Start Qty:** 2.00 **Cust Item ID:**

Required Date: 10/20/2010 **Req'd Qty:** 2.00 **Customer:**

Reference:

Run Start **Stop**

Approvals: **Process Plan:** ______ **Date:** ______ **Tooling:** ______ **Date:** ______

QC: ______ **Date:** ______ **SPC (Y/N):** ______ **Date:** ______

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 Packaging Packaging	Packaging	0.00							
	Memo Identify and pack for shipping as per PPP D350-588-011 Location:______ PPP Rev: C	0.00							
140 QC Quality Control	QC21- Final Inspection - Work Order Release	0.00							
	Memo	0.00							

Handwritten: Pu 10/10/28 (2); 10/10/29; 10-10-28 (2)

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W/O:	WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: ____________________ PAR #: _______ Fault Category: __________________ NCR: Yes No DQA: _____ Date: _________

Resolution: ____________________ Disposition: ____________________ QA: N/C Closed: _________ Date: _________

NCR:	WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Monday, October 04, 2010 10:58:20 AM

8

Work Order ID: 62554

Parent Item: D350-588-011

Parent Item Name: Aft Door Fwd Hinge Modification

Start Date: 10/4/2010 **Required Date:** 10/20/2010

Start Qty: 2.00 **Required Qty:** 2.00

Comments: IPP Rev:M□04.08.31□Added D2690-17□KJ/JLM□

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
AN526C1032R7 Screw		Purchased	No			120	Each	60.0000	2	4	4		
AN526C832R8 Screw		Purchased	No			120	Each	188.0000	8	16			
AN526C832R9 Screw		Purchased	No			120	Each	69.0000	8	16		10/14/2010	

AN526C1032R7 locations:

Location		Loc Qty	Loc Code
ST328		60	
	113064	9	
	113749	1	
	114056	50	

M113064 24
M114056 24

AN526C832R8 locations:

Location		Loc Qty	Loc Code
ST327		188	
	114615	88	
	114718	100	

M114615

M115838

AN526C832R9 locations:

Location		Loc Qty	Loc Code
ST327		69	
	115422	69	

~~M1154~~

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W/O:	WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: ____________ **PAR #:** ______ **Fault Category:** ____________ **NCR:** Yes No **DQA:** _____ **Date:** ________

Resolution: ____________ **Disposition:** ____________ **QA: N/C Closed:** ________ **Date:** ________

NCR:	WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Monday, October 04, 2010 10:58:20 AM

Work Order ID: 62554

Parent Item: D350-588-011

Parent Item Name: Aft Door Fwd Hinge Modification

Start Date: 10/4/2010 **Required Date:** 10/20/2010

Start Qty: 2.00 **Required Qty:** 2.00

Item	Part	Type				UOM	Cost	Qty	Handwritten
~~AN960JD10~~ Washer	NAS1149D0363J	Purchased	No	120		Each	8.0000	4	8 M110622
~~AN960JD8~~ Washer	NAS1149DN832 J	Purchased	No	120		Each	10.0000	24	48 M115832 M110996
D2143 Hinge Bracket		Manufactured	No	120		Each	17.0000	1	2
D2144 Hinge Bracket		Manufactured	No	120		Each	42.0000	1	2

AN960JD10 Washer locations:

Location	Loc Qty	Loc Code
ST	6	
107715	6	
ST335	2	
105792	2	

AN960JD8 Washer locations:

Location	Loc Qty	Loc Code
ST347	10	
105059	10	

D2143 Hinge Bracket locations:

Location	Loc Qty	Loc Code
ST198	17	
55323	17	55323

D2144 Hinge Bracket locations:

Location	Loc Qty	Loc Code
ST198	42	
55179	42	55179

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W/O:		WORK ORDER CHANGES					
DATE	**STEP**	**PROCEDURE CHANGE**	**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector

Part No: ____________________ **PAR #:** _______ **Fault Category:** __________________ **NCR:** Yes No **DQA:** _____ **Date:** _________

Resolution: ____________________ **Disposition:** ____________________ **QA: N/C Closed:** __________ **Date:** _________

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	**STEP**	**Description of NC** Section A	**Corrective Action** Section B			**Verification** Section C	**Approval** Chief Eng	**Approval** QC Inspector
			Initial Chief Eng	**Action Description** Chief Eng	**Sign & Date**			

NOTE: Date & initial all entries

Picklist Print

Monday, October 04, 2010 10:58:21 AM

Work Order ID: 62554

Parent Item: D350-588-011

Parent Item Name: Aft Door Fwd Hinge Modification

Start Date: 10/4/2010 **Required Date:** 10/20/2010

Start Qty: 2.00 **Required Qty:** 2.00

Item	Type				Qty		
D2150 Packer Doubler, Hinge	Manufactured	No	120	Each	34.0000	2	4
D2151 Packer Doubler, Hinge	Manufactured	No	120	Each	19.0000	2	4
D2153 Door Prop	Manufactured	No	120	Each	24.0000	1	2
D2154 Stud Bracket	Manufactured	No	120	Each	10.0000	1	2
D2237 Striker Plate	Manufactured	No	120	Each	25.0000	2	4

D2150 locations:

Location	Loc Qty	Loc Code
ST007	34	
55178	34	

D2151 locations:

Location	Loc Qty	Loc Code
ST007	19	
55319	19	

D2153 locations:

Location	Loc Qty	Loc Code
ST272	24	
59818	24	

D2154 locations:

Location	Loc Qty	Loc Code
ST007	10	
55325	10	

D2237 locations:

Location	Loc Qty	Loc Code
ST009	25	
58181	3	
60492	22	

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: ____________ **PAR #:** ______ **Fault Category:** ____________ **NCR:** Yes No **DQA:** _____ **Date:** ________

Resolution: ____________ **Disposition:** ____________ **QA: N/C Closed:** ________ **Date:** ________

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID: 62554

Parent Item: D350-588-011

Parent Item Name: Aft Door Fwd Hinge Modification

Start Date: 10/4/2010 **Required Date:** 10/20/2010

Start Qty: 2.00 **Required Qty:** 2.00

D2461 Manufactured No 120 f 182.9772 7.25 15.26316

Neoprene "D" Seal

Location	Loc Qty	Loc Code
ST402	182.9772105	
39782	6.5	
55054	176.477211	55054

S+2

cut 1 X 87.00" → measured 8 10/10/25

D2463 Manufactured No 120 f 134.5248 7.25 15.26316

62557

Seal

Location	Loc Qty	Loc Code
ST404	134.5248105	
43841	3	
50075	11.3536	
55561	120.171211	55561 7-25

S+2

cut 1 X 87.00" → measured 8 10/10/25

D2583 Manufactured No 120 Each 30.0000 2 4

10/10/25 (2)

Latch Bracket

Location	Loc Qty	Loc Code
ST017	28	
60497	4	
61715	24	61715
ST018	2	
56527	2	

S+2

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: ____________________ PAR #: _______ Fault Category: ________________ NCR: Yes No DQA: _____ Date: _________

Resolution: ___________________ Disposition: ____________________ QA: N/C Closed: __________ Date: _________

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
			Corrective Action Section B					
DATE	STEP	Description of NC Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Verification Section C	Approval Chief Eng	Approval QC Inspector

NOTE: Date & initial all entries

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Picklist Print

Monday, October 04, 2010 10:58:21 AM

Work Order ID: 62554

Parent Item: D350-588-011

Parent Item Name: Aft Door Fwd Hinge Modification

Start Date: 10/4/2010 **Required Date:** 10/20/2010

Start Qty: 2.00 **Required Qty:** 2.00

D2585 Mounting Channel — Manufactured — No — 120 — Each — 38.0000 — 2 — 4

Location	Loc Qty	Loc Code
ST019	38	
56524	1	
59118	11	
59873	26	

59118

D2586 Door Latch — Manufactured — No — 120 — Each — 76.0000 — 2 — 4

Location	Loc Qty	Loc Code
ST006	16	
57917	16	
ST204	60	
61655	60	

57917

D2587 Door Slug, 350 Hinge — Manufactured — No — 120 — Each — 20.0000 — 1 — 2

Location	Loc Qty	Loc Code
ST019	20	
56555	20	

56555

D2589 Keys, Key Chain, 350 Hinge — Manufactured — No — 120 — Each — 173.0000 — 1 — 2

10/14/25 (2)

Location	Loc Qty	Loc Code
ST019	173	
58194	173	

58194

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W/O:	WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: ____________ **PAR #:** _______ **Fault Category:** ____________ **NCR:** Yes No **DQA:** _____ **Date:** _________

Resolution: ____________ **Disposition:** ____________ **QA: N/C Closed:** ________ **Date:** _________

NCR:	WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Work Order ID: 62554

Parent Item: D350-588-011

Parent Item Name: Aft Door Fwd Hinge Modification

Start Date: 10/4/2010 **Required Date:** 10/20/2010

Start Qty: 2.00 **Required Qty:** 2.00

Item	Type			UOM	Qty		
D2690-17 Cable	Manufactured	No	120	Each	3.0000	1	2 62450

Location		Loc Qty	Loc Code
ST021		3	
	58212	3	

Item	Type			UOM	Qty		
D2857-1 Hinge Bracket	Manufactured	No	120	Each	35.0000	1	2

Location		Loc Qty	Loc Code
ST026		35	
	56529	10	56529
	57924	23	
	61525	2	

Item	Type			UOM	Qty		
D2857-2 Hinge Bracket	Manufactured	No	120	Each	39.0000	1	2

Location		Loc Qty	Loc Code
ST027		39	
	55020	1	
	56530	12	56530
	57925	24	
	61529	2	

Item	Type			UOM	Qty		
D2858-1 Hinge Bracket	Manufactured	No	120	Each	22.0000	1	2 10/10/05

Location		Loc Qty	Loc Code
ST027		22	
	56423	16	56423
	61522	6	

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: ____________________ PAR #: ______ Fault Category: _________________ NCR: Yes No DQA: _____ Date: ________

Resolution: ___________________ Disposition: ____________________ QA: N/C Closed: _________ Date: ________

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID: 62554

Parent Item: D350-588-011

Parent Item Name: Aft Door Fwd Hinge Modification

Start Date: 10/4/2010 **Required Date:** 10/20/2010

Start Qty: 2.00 **Required Qty:** 2.00

Item	Type			Unit	Qty		
D2858-2 Hinge Bracket	Manufactured	No	120	Each	14.0000	1	2

Location		Loc Qty	Loc Code
ST027		14	
	56048	8	
	61523	6	

56048

Item	Type			Unit	Qty		
FG-778150-550-ROL 7781 9oz Glass 50"x125yd	Purchased	No	120	sf	1,904.750	1	2

Location		Loc Qty	Loc Code
ST404		1904.75	
	108932	18	
	111166	402	
	113905	1484.75	

-1

M111166 1/6

1- cut 1 squarre ft of glass cloth

Item	Type			Unit	Qty		
MS20426AD3-4 RIVET	Purchased	No	120	Each	6,356.000	12	24

Location		Loc Qty	Loc Code
ST316		6356	
	104374	2356	
	110398	4000	

M104374

Item	Type			Unit	Qty		
MS20470AD4-5 Rivet, Universal Head	Purchased	No	120	Each	941.0000	18	36

10/14/25 (2)

Location		Loc Qty	Loc Code
ST309		876	
	114761	876	
ST319		65	
	111916	65	

M114761

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W/O:	WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: ____________________ PAR #: _______ Fault Category: __________________ NCR: Yes No DQA: _____ Date: _________

Resolution: ____________________ Disposition: ____________________ QA: N/C Closed: __________ Date: _________

NCR:	WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID: 62554

Parent Item: D350-588-011

Parent Item Name: Aft Door Fwd Hinge Modification

Start Date: 10/4/2010 **Required Date:** 10/20/2010

Start Qty: 2.00 **Required Qty:** 2.00

Item	Type							
MS21042L08 Nut	Purchased	No	120	Each	177.0000	18	36	M115300
MS21042L3 Nut	Purchased	No	120	Each	1,720.000	4	8	M114784
MS27039-08-11 Screw	Purchased	No	120	Each	59.0000	2	4	M114382
MS27039-1-15 Screw	Purchased	No	120	Each	67.0000	2	4	M113749 3x, M114718

MS21042L08:

Location		Loc Qty	Loc Code
ST300		177	
	115300	177	

MS21042L3:

Location		Loc Qty	Loc Code
ST300		1720	
	114523	49	
	114784	1671	

MS27039-08-11:

Location		Loc Qty	Loc Code
ST288		50	
	114382	50	
ST290		9	
	113749	9	

MS27039-1-15:

Location		Loc Qty	Loc Code
ST292		67	
	114056	2	
	114718	65	

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: ____________ **PAR #:** ______ **Fault Category:** ____________ **NCR:** Yes No **DQA:** _____ **Date:** ________

Resolution: ____________ **Disposition:** ____________ **QA: N/C Closed:** ________ **Date:** ________

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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52.3 WEIGHT AND BALANCE

Installation	Weight	LATERAL		LONGITUDINAL	
		Arm	Moment	Arm	Moment
D350-588-011 Aft Door Fwd Hinge Modification Kit	1.0 lb 0.45 Kg	-21.0 in -0.53 m	-21.0 in-lb -0.24 m-Kg	+170.0 in +4.32 m	+170.0 in-lb +1.96 m-Kg
D350-588-041* Aft Door Assembly	2.0 lb 0.91 Kg	-21.0 in -0.53 m	-42.0 in-lb -0.48 m-Kg	+170.0 in +4.32 m	+340.0 in-lb +3.93 m-Kg

* D350-588-041 Aft Door Assembly weight in excess of standard Eurocopter Door.

52.4 PARTS LISTS

588 -041	588 -011	Part Number	Description
X		**D350-588-041**	**AFT DOOR ASSEMBLY**
	X	**D350-588-011**	**AFT DOOR FWD HINGE MODIFICATION KIT**
1	1	D2143	HINGE DOUBLER
1	1	D2144	HINGE DOUBLER
2	2	D2150	HINGE PACKER
2	2	D2151	HINGE DOUBLER
1	1	D2153-3315-10	GAS SPRING ASSY.
1	1	D2154	STUD BRACKET
2	2	D2237	STRIKER PLATE
1		D2445	DOOR
1	1	D2461-0870	NEOPRENE D SEAL
1	1	D2463-0870	½" FOAM SEAL
	2	D2583	LATCH BRACKET
2	2	D2585	LATCH CLAMP
2	2	D2586	LATCH
	1	D2587	PLUG
1	1	D2589	KEYS, KEY CHAIN
2		D2621	LATCH PLATE
1	1	D2690-17	CABLE, DOOR STOP
1	1	D2857-1	LOWER HINGE BRACKET
1	1	D2857-2	UPPER HINGE BRACKET
1	1	D2858-1	LOWER HINGE BRACKET
1	1	D2858-2	UPPER HINGE BRACKET
8	8	AN526C832R8	SCREW (or AN526-832R8)
8	8	AN526C832R9	SCREW (or AN526-832R9)
2	2	AN526C1032R7	SCREW (or AN526-1032R7)
24	24	AN960JD8	WASHER
4	4	AN960JD10	WASHER
12	12	MS20426AD3-4	RIVET
18	18	MS20470AD4-5	RIVET
18	18	MS21042L08	NUT (or MS21042-08)
4	4	MS21042L3	NUT (or MS21042-3)
2	2	MS27039-1-15	SCREW
2	2	MS27039-0811	SCREW
1	1	N/A	1 SQUARE ft. OF 9 oz. GLASS CLOTH (S-CLASS)